

Date: Tuesday, 1/24/2006 7:46:13 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LEFT ARM WELDMENT
Job Number :	25596		
Estimate Number :	12080		
P.O. Number :	N/A	Part Number :	D33543
This Issue :	1/24/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3354 REV. A
First Issue :	N/A	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	1/31/2006
Written By :	<u>SEE COMMENT BELOW</u>		Qty: 8 Um: Each
Checked & Approved By :	<u>SEE COMMENT BELOW</u>		
Comment :	est rev A 06.01.23 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR1250	4130N ROUND BAR
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Comment: Qty.: 0.6300 f(s)/Unit Total : 5.0400 f(s)
 AISI 4130 ROUND BAR 1.250" dia. batch: M18490

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA623 & DWG D3354

FOLIO REV: ADWG REV: A

2-DEBURR AS REQUIRED

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Handwritten signature 06-01-24

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1-Drill cotter pin hole as per dwg D3354

2-Deburr

Handwritten signature 06-01-24

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Handwritten signature 06-01-24

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Seq. #:

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Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 420

06/11/25 (8)

7.0

DC

DOCUMENT CONTROL






Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/25 (8) *06/01/25*

Job Completion



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED	DRAWING NO. D3354	REV. A SHEET 4 OF 8
DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:1



1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS#-G41400 ROUND BAR, Ø1.250 (REF. DART SPEC. M4140H-R)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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